

Date: Thursday, 02/10/2008 10:34:25 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE, OUTBOARD, LS, 206
<b>Job Number</b> : 42409	
<b>Estimate Number</b> : 11011	
<b>P.O. Number</b> :	<b>Part Number</b> : D26671
<b>This Issue</b> : 02/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2667 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 25/10/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08.10.02</u>	
<b>Comment</b> : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
 7075-T7351 2X6.25X7.875  
 Issue material from stock: 7075-T7351  
 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length  
 Batch No: B34644 X9 B25348X1

JL 08/11/12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 3-Fixturing Inspection last completed on 08/11/11 by JL  
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 7- Deburr

JL 08/11/12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

JL 08/11/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Thursday, 02/10/2008 10:34:25 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LS, 206

Job Number: 42409

Part Number: D26671

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SI 08/11/12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SI 08/11/12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h

08/11/17

10X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30  
320°C  
2:00

M-h

08/11/17

10X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-17

10X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST427

SS

08/11/18

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18

Job Completion



mf 08-11-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42409
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2667-1
<b>Inspection Dwg:</b> D2667 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2 ?	3	4		
A	0.100	0.140		.121	.121	.121	.120		
B	0.100	0.140		.111	.113	.115	.115		
C	1.125	1.145		1.135	1.137	1.137	1.134		
D	0.615	0.685		.625	.625	.625	.625		
E	0.240	0.260		.252	.251	.252	.253		
F	1.313	1.343		1.327	1.327	1.328	1.327		
G	0.210	0.230		.219	.220	.220	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.492	2.492	2.492	2.492		
J	1.565	1.585		1.573	1.573	1.574	1.570		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.113	.113	.113	.112		
M	0.990	1.010		1.000	1.000	1.000	.999		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		5.999	6.001	6.000	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.320	.320	.320	.320		
T	1.995	2.005		2.000	2.000	2.000	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.797	.797	.797		
W	1.040	1.060		1.050	1.052	1.051	1.052		
X	1.674	1.679		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.921	.921	.921	.920		
AA	0.490	0.510		.499	.498	.499	.495		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JK
Date:	08/11/11

Audited by:	84
Date:	08/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42409
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2667-1
<b>Inspection Dwg:</b> D2667 Rev. D	<b>Page 1 of 1</b>

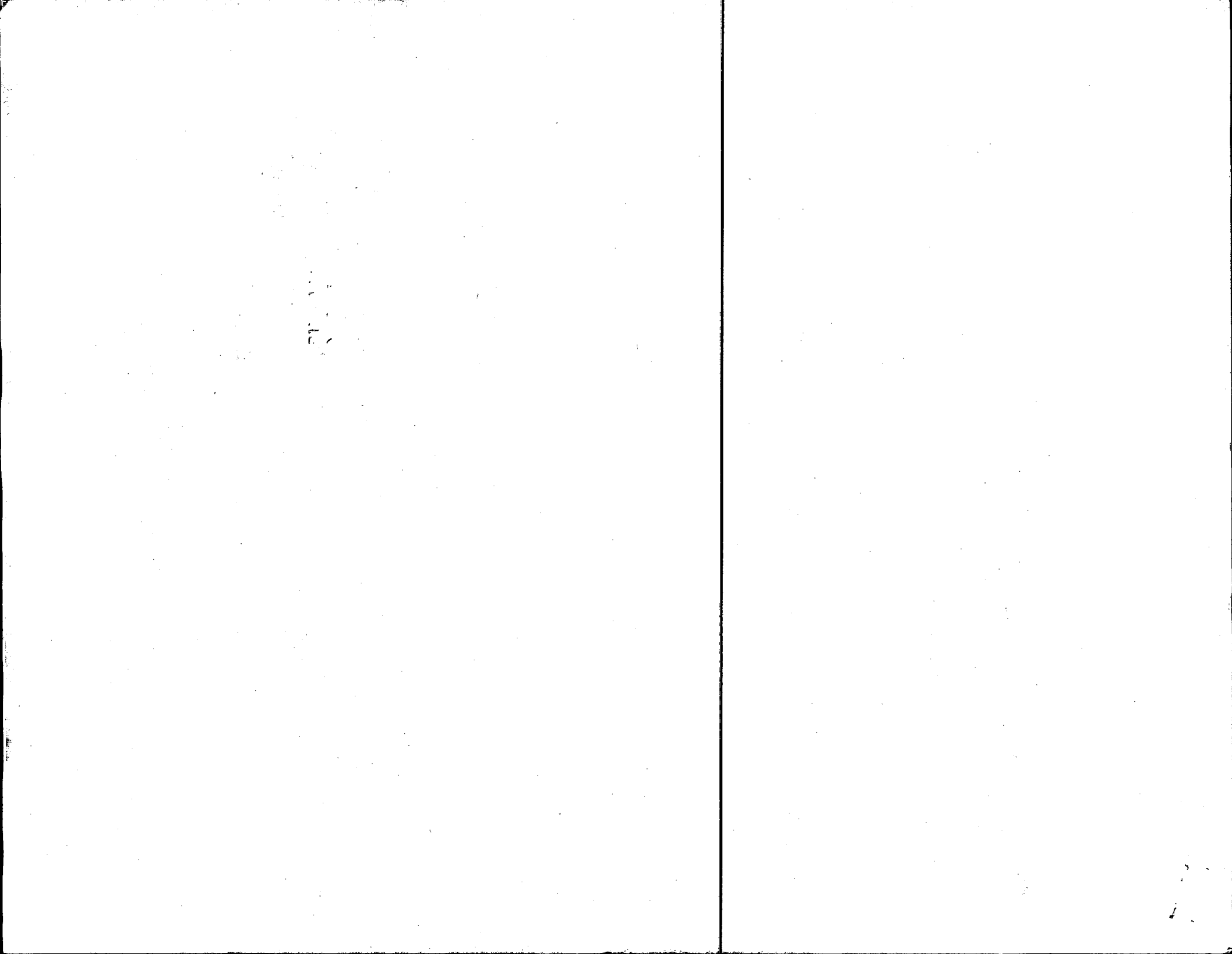
Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.100	0.140		.121	.121	.122	.121		
B	0.100	0.140		.117	.116	.117	.117		
C	1.125	1.145		1.133	1.137	1.139	1.138		
D	0.615	0.685		.625	.625	.625	.625		
E	0.240	0.260		.254	.254	.250	.252		
F	1.313	1.343		1.327	1.327	1.328	1.327		
G	0.210	0.230		.219	.220	.221	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.492	2.492	2.492	2.492		
J	1.565	1.585		1.569	1.574	1.575	1.574		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.113	.113	.113	.113		
M	0.990	1.010		.999	.999	.999	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.320	.320	.320	.320		
T	1.995	2.005		2.000	2.000	2.000	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797		
W	1.040	1.060		1.051	1.051	1.052	1.051		
X	1.674	1.679		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.921	.921		
AA	0.490	0.510		.499	.499	.499	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JL
Date:	08/11/12

Audited by:	SP
Date:	08/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description: 206 Saddle, Outboard, Left side</b>	<b>Part Number:</b>	<b>D2667-1</b>
<b>Inspection Dwg: D2667 Rev. D</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

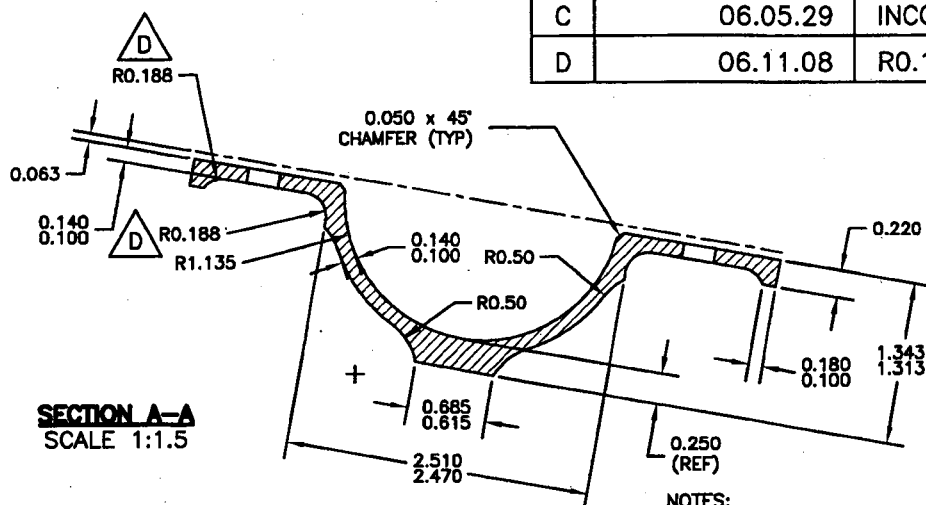
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	<del>19</del>	<del>20</del>	<del>3</del>	<del>4</del>	By	Date
A	0.100	0.140		.121	.120				
B	0.100	0.140		.117	.116				
C	1.125	1.145		1.137	1.138				
D	0.615	0.685		.625	.625				
E	0.240	0.260		.252	.252				
F	1.313	1.343		1.327	1.327				
G	0.210	0.230		.220	.221				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.492	2.492				
J	1.565	1.585		1.574	1.575				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.113	.113				
M	0.990	1.010		1.000	1.000				
N	0.510	0.515		.510	.510				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.314	.314				
S	0.315	0.322		.320	.320				
T	1.995	2.005		2.000	2.000				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.796	.797				
W	1.040	1.060		1.052	1.051				
X	1.674	1.679		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.921	.921				
AA	0.490	0.510		.500	.499				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>SL</u>	Audited by: <u>87</u>
Date: <u>08/11/12</u>	Date: <u>08/11/12</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



DESIGN #1		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH		APPROVED #1		DRAWING NO. REV. D D2667 SHEET 1 OF 1	
DATE 06.11.08		TITLE SCALE SADDLE AFT OUTSIDE HIGH 1:3			
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313			



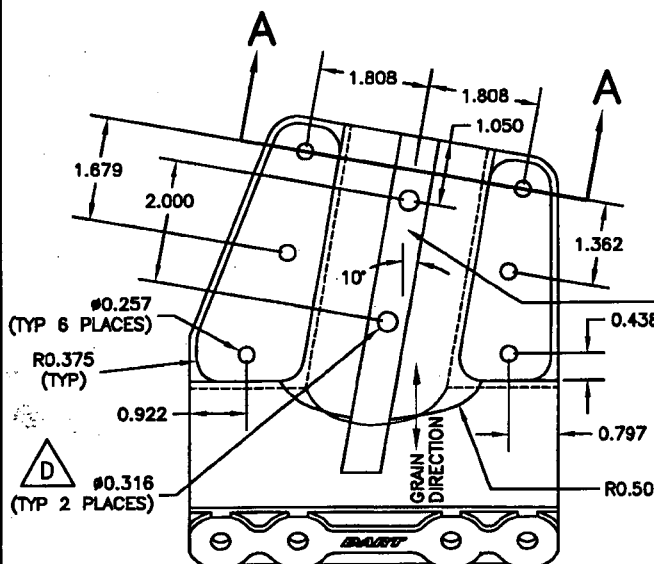
RELEASED

07.02.12

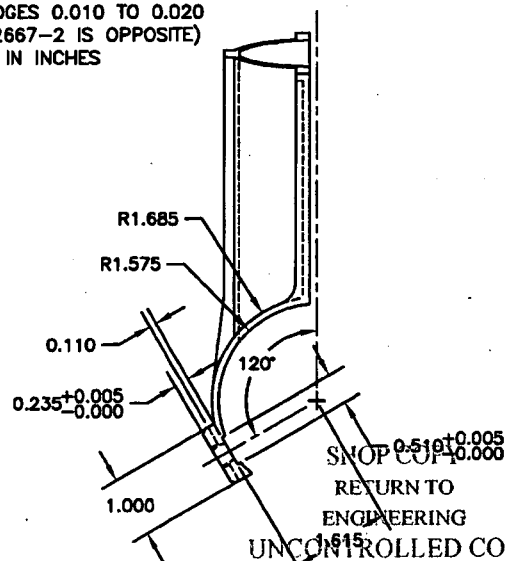
**SECTION A-A**  
**SCALE 1:1.5**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BUILT, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2667-1 SHOWN (D2667-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

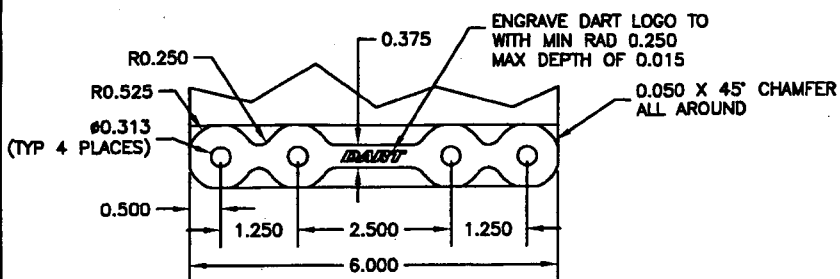


ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42409

**D2667-1 SADDLE AFT OUTSIDE HIGH**



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